

AMENDMENTS TO THE ABSTRACT:

Page 14

Please amend page 14 as follows:

ABSTRACT

~~The invention concerns a~~ A method for determining a deviation of at least one regulating variable on chip removal machines with a mechanical drive for a tool and/or a workpiece, regulated by a control system, wherein the regulation comprises a plurality of values $[[C, X, Z]]$ of at least three spatial axes $[[c, x, z]]$ for the control system and for the drive, and the values $[[C, X, Z]]$ have a functional relation ~~such as~~ $Z = f_{bi}(C, X)$ with the axes $[[c, x, z]]$. A protocol is prepared from a plurality of control system actual values $[[C_{p,s}, X_{p,s}, Z_{p,s}]]$ detected by measuring means and/or selected drive actual values $[[C_{p,a}, X_{p,a}, Z_{p,a}]]$ and a control system nominal value $[[$ according to $Z_{bi,s} = f_{bi}(C_{p,s}, X_{p,s})$ and/or a drive nominal value ~~according to~~ $Z_{bi,a} = f_{bi}(C_{p,a}, X_{p,a})$ is calculated at least in relation to an axis ~~the z-axis~~, and a control system differential value ~~according to~~ $D_{z,s} = Z_{p,s} - Z_{bi,s}$ and/or a drive differential value ~~according to~~ $D_{z,a} = Z_{p,a} - Z_{bi,a}$ is calculated at least in relation to the axis $[[z\text{-axis}]]$. ~~The invention also pertains to a~~ A chip removal machine which implements such a method is also disclosed.